

GREEN

Dart Aerospace Ltd.

Date: Thursday, 22/01/2009 7:54:29 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG T-HANDLE ASSEMBLY
Job Number : 45026	
Estimate Number : 13522	
P.O. Number :	Part Number : PB674300151
This Issue : 22/01/2009 S.O. No. :	Drawing Number : B6743001 P.13
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 41381	Material :
Written By :	Due Date : 28/01/2009 Qty: 9 Um: Each
Checked & Approved By : <u>MF 09-01-22</u>	
Comment : Est Rev:A 08-07-25 new issue DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300187	Tube Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Tube Arm

batch: B41518 ✓

MF 09-02-25 9

2.0	PB674300191	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Tube Handle

batch: B41519 = 8 B41216 = 1 *

MF 09-02-25 9

3.0	PB674300193	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 18.0000 Each(s)

Tube End Cap

batch: B41520

MF 09-02-25 9

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

MF 09-02-25 9

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/02/26 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 45026

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-26 (9)

7.0

PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

Clevis

batch:

340093 = 2

323986B = 7

FL 09-02-26 9

8.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

SPRING SLOTTED PIN

batch:

117850

FL 09-02-26 9

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg
2- install spring pin

FL 09-02-26 9

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/02/26 (9)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

8:20am

OVEN TEMPERATURE:

320°C

FINISH TIME:

8:50am

FL 09-02-27 (9)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/27 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Process Sheet

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Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pkg Blade Fld

SS 09/02/27 09

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



MF 09-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

